

September-21-12 2:12:09 PM

90677

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 21/09/2012 **Start Qty:** 20.00

20

Customer:

Required Date: 02/11/2012 Req'd Qty: 20.00

20

Reference:

Approvals: Process Plan: *MLJ*

Date: 12-09-21

Tooling:

Date:

Run Start *NR1*

QC:

Date:

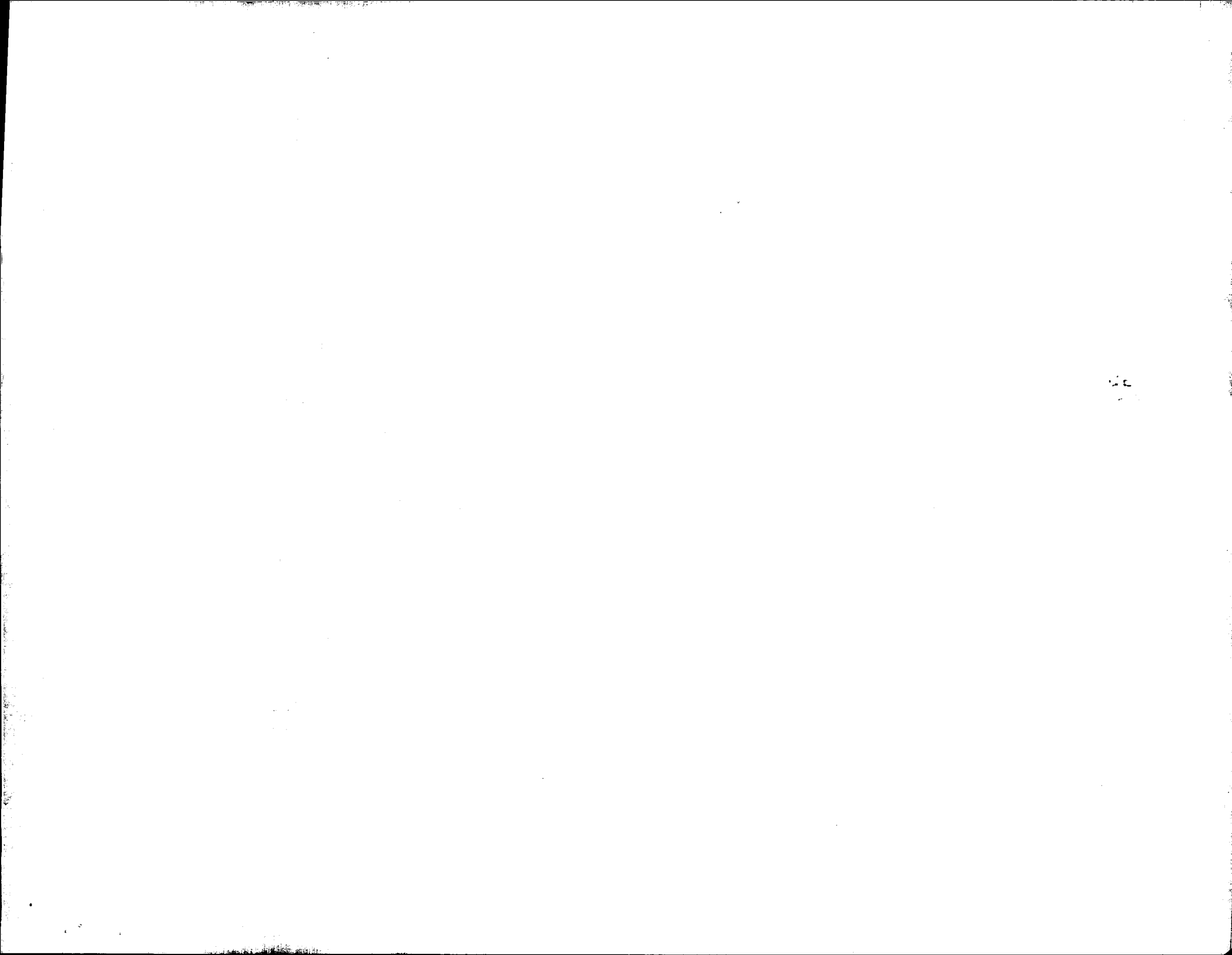
SPC (Y/N):

Date:

Stop *NR2*

[illegible]

22



Work Order ID 90677

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90677

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Item ID: D2940-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Support

Stop ***NS2***

Start Date: 21/09/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 02/11/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/11/19 *[Signature]*
ME
12-11-25

Picklist Print

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Work Order ID: 90677

90677

Parent Item: D2940-1

D2940-1

Parent Item Name: Support

Start Date: 21/09/2012

Required Date: 02/11/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP C 02.11.26 Reformat; Added P/OKJ
IPP Rev:D Added priming as per Rev B 07-04-30 JLM
IPP E 08.03.19 Re-format Ec verified by DD
IPP Rev:F 08-10-22 add qc14 DD verified by:EC
11.08.04 as per dwg rev.C DD verf:EC
IPP Rev:G

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK081		Manufactured	No			110	Each	15.0000	0.5	10.52632			

DSK081

D2940-1 TURNING DETAIL

**

PO 12/11/05

Location

Loc Qty

Loc Code

MAT060

15

88241

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88709

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DART AEROSPACE LTD		Work Order:	90677
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.147	.147	.146	.144	.148
AD	3.510	3.530		3.525	3.525	3.525	3.523	3.525
AE	1.633	1.673		1.663	1.662	1.660	1.662	1.662
AF	1.493	1.513		1.506	1.502	1.506	1.506	1.507
AG	0.040	0.060		.048	.044	.050	.050	.047
AH	0.188	0.193		.188	.188	.188	.188	.188
AI	0.140	0.160		.145	.149	.151	.149	.149
AJ	2.518	2.538		2.528	2.530	2.530	2.529	2.528
AK	0.040	0.060		.046	.046	.046	.046	.046
AL	0.010	0.020		.015	.015	.015	.015	.015
AM	0.140	0.160		.141	.140	.140	.140	.140
AN	0.350	0.450		.370	.370	.365	.365	.365
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.157	.160	.154	.156	.156
AQ	0.053	0.073		.070	.070	.070	.070	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.260	.260	.260	.260	.260
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.125	4.127	4.130	4.131	4.133
AV								
AW								
Accept/Reject								

Measured by: PD / EK 12/11/08	Date: 12/11/06
Audited by: JAS 94 8-80	Date: 12/11/13
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	

DART AEROSPACE LTD		Work Order:	90677
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.150	.147	.148	.151	.150
AD	3.510	3.530		3.523	3.523	3.523	3.523	3.523
AE	1.633	1.673		1.663	1.661	1.660	1.665	1.661
AF	1.493	1.513		1.506	1.504	1.504	1.510	1.505
AG	0.040	0.060		.049	.049	.049	.049	.049
AH	0.188	0.193		.188	.188	.188	.188	.188
AI	0.140	0.160		.151	.150	.151	.153	.153
AJ	2.518	2.538		2.527	2.526	2.525	2.528	2.524
AK	0.040	0.060		.047	.046	.046	.047	.049
AL	0.010	0.020		.015	.015	.015	.015	.015
AM	0.140	0.160		.140	.140	.140	.140	.140
AN	0.350	0.450		.365	.365	.365	.365	.365
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.156	.157	.156	.155	.154
AQ	0.053	0.073		.063	.070	.070	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.260	.260	.260	.260	.260
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.131	4.135	4.134	4.136	4.132
AV								
AW								
Accept/Reject								

Measured by:	FK / PD	Date:	12/11/08 / 12/11/09
Audited by:	14 DAS	Date:	12/11/13
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	

DART AEROSPACE LTD		Work Order: 90677
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.152	.152	.152	.151	.153
AD	3.510	3.530		3.522	3.524	3.522	3.523	3.523
AE	1.633	1.673		1.659	1.663	1.662	1.662	1.660
AF	1.493	1.513		1.508	1.505	1.506	1.508	1.507
AG	0.040	0.060		.052	.050	.052	.052	.051
AH	0.188	0.193		.188	.188	.188	.188	.188
AI	0.140	0.160		.153	.151	.155	.154	.153
AJ	2.518	2.538		2.524	2.527	2.523	2.526	2.530
AK	0.040	0.060		.047	.050	.047	.049	.049
AL	0.010	0.020		.015	.015	.015	.015	.015
AM	0.140	0.160		.140	.140	.140	.140	.140
AN	0.350	0.450		.365	.365	.365	.365	.365
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.1536	.155	.152	.153	.153
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.260	.260	.260	.260	.260
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.132	4.137	4.132	4.134	4.137
AV								
AW								
Accept/Reject								

Measured by: FK DAS	Date: 12/11/12
Audited by: 14 <i>one</i>	Date: 12/11/13
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	

DART AEROSPACE LTD		Work Order: 90677
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.151	.151	.150	.150	.148
AD	3.510	3.530		3.523	3.525	3.522	3.522	3.522
AE	1.633	1.673		1.662	1.662	1.662	1.662	1.660
AF	1.493	1.513		1.506	1.505	1.508	1.508	1.504
AG	0.040	0.060		.051	.051	.050	.052	.048
AH	0.188	0.193		.188	.188	.188	.188	.188
AI	0.140	0.160		.154	.153	.154	.154	.154
AJ	2.518	2.538		2.529	2.525	2.525	2.522	2.521
AK	0.040	0.060		.045	.046	.047	.050	.047
AL	0.010	0.020		.015	.015	.015	.015	.015
AM	0.140	0.160		.140	.140	.140	.140	.140
AN	0.350	0.450		.365	.365	.365	.365	.365
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.156	.157	.154	.154	.156
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.260	.260	.260	.260	.260
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.138	4.135	4.135	4.132	4.132
AV								
AW								
Accept/Reject								

Measured by: F.A.	Date: 12/11/12.
Audited by: DAS 14 8-89	Date: 12/11/13
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	

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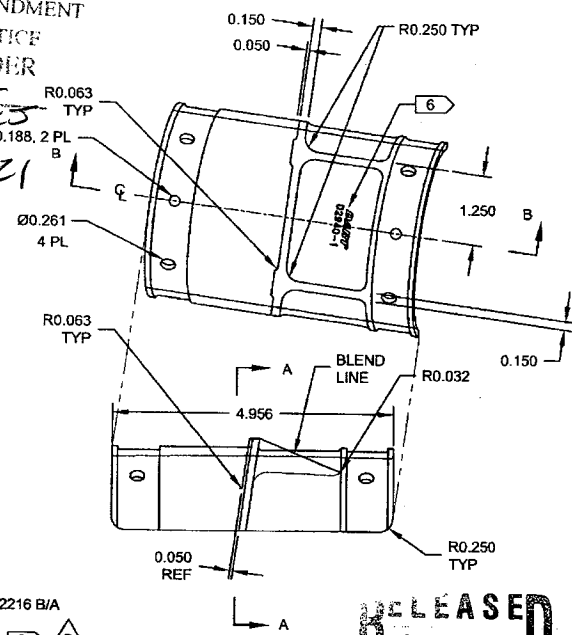
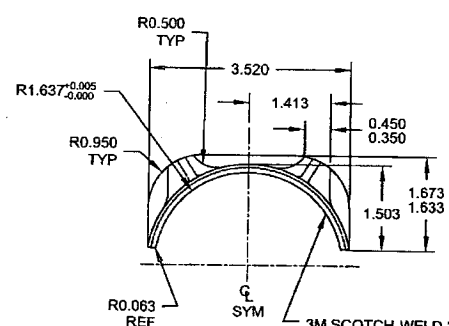
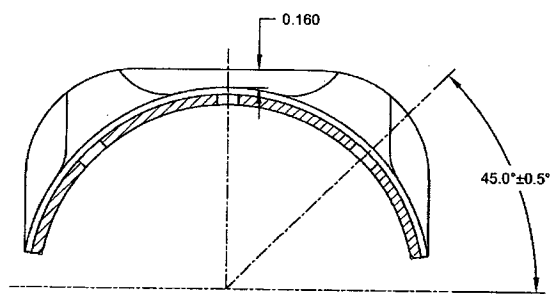
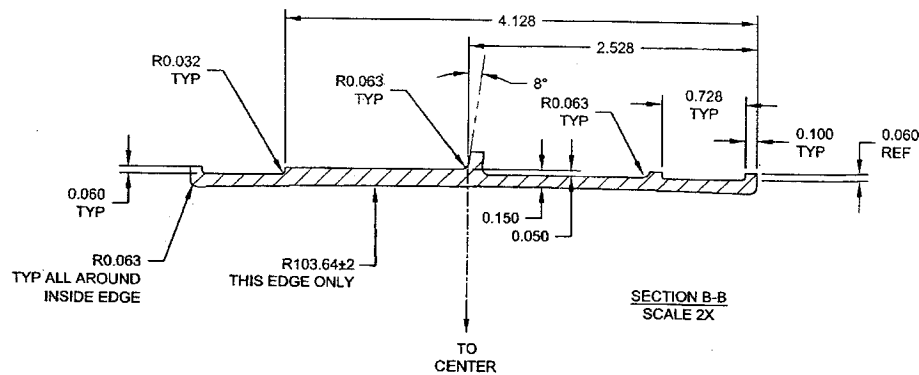
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SHOWN
RETURNING
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 90677
1209-21

RELEASED
2011-07-28

NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRC)
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ±0.010) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.
- 7) WEIGHT: 0.92 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

D2940-1 SUPPORT

C	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION	CP	11.07.15
B	UPDATE PER NCR 642, PRIME INSIDE	PH	07.03.13
A	NEW ISSUE	CP	01.01.10
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2940
SHEET 1 OF 1
REV. C
TITLE Ø3.250 SUPPORT
SCALE NTS

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